ARMSCOR

USER'S MANUAL

MODEL 1600

SEMI AUTOMATIC RIFLE

WARNING

READ THE INSTRUCTIONS AND SAFETY PRECAUTIONS IN THIS MANUAL CAREFULLY BEFORE USING THIS FIREARM.

DISCHARGING FIREARMS IN POORLY VENTILATED AREAS, CLEANING FIREARMS OR HANDLING AMMUNITION MAY RESULT IN EXPOSURE TO LEAD AND OTHER SUBSTANCES KNOWN TO THE STATE OF CALIFORNIA TO CAUSE BIRTH DEFECTS, REPRODUCTIVE HARM AND OTHER SERIOUS PHYSICAL INJURY. HAVE ADEQUATE VENTILATION AT ALL TIMES. WASH HANDS YOUR THOROUGHLY AFTER EXPOSURE.

M 1600 OPERATING INSTRUCTIONS

This rifle is shipped from the factory fully assembled and ready to shoot after removing the grease from its bore.

TO LOAD MAGAZINE:

Hold the magazine box firmly with one hand and, with the other, insert cartridge at the throat of the magazine. Push the cartridge against the spring follower head down and forward towards the supporting notch until it is securely locked. A maximum of fifteen rounds can be loaded.

TO ATTACH MAGAZINE:

Load the magazine into the magazine box clearance of the trigger guard housing. Keep it ahead of the magazine catch by pushing it inward until it locks in place.

TO DETACH MAGAZINE:

Press magazine release and, simultaneously, pull the magazine from guard. The catch opens up and releases the magazine from lock.

TO MAKE GUN SAFE:

Safety lever is at the right side of the receiver and rearward of the bolt operating handle. Pull safety latch towards the "S" mark engraved on the receiver. Trigger is locked up in the process and gun can no longer be fired.

TO LOAD CHAMBER:

Draw safety on and insert a loaded magazine into the rifle. Retract bolt handle fully to the rear of the receiver slot and release. Allow the bolt to be snapped back under the full force of the operating springs. Bolt automatically picks up a cartridge from the magazine and feeds it into the chamber. Do not ease bolt forward.

TO FIRE:

Be sure gun is pointed at a safe target. Release safety and pull the trigger. Pressure from the burning powder opens up bolt, ejects empty shell, and reloads the chamber for the next shot. Pull the trigger again. Gun fires as fast as the trigger is pulled until magazine is empty.

TO UNLOAD WITHOUT FIRING:

Draw safety on and release the magazine from guard. Work action several times to remove any cartridge left inside the chamber. Slide bolt handle rearward and lock piece. Inspect the chamber to make sure no cartridge is left. Empty magazine can be placed back if desired.

I. DISASSEMBLY

A. STOCK AND TRIGGER GUARD HOUSING

1. **Remove the magazine by depressing the magazine catch.**
2. **Remove front screw of trigger guard housing and detach barrel-receiver assembly from the stock.**

B. TRIGGER GROUP

1. **Remove the trigger by punching out trigger stop pin and pivot pin.**
2. **Remove the trigger spring and spring follower at the end of the housing.**
3. **Loosen the rear and front (trigger) housing hold down screws to disengage the housing from the receiver.**

   CAUTION: Step number 3 is not recommended unless necessary. If it could not be avoided, make sure to apply "Loctite" or Epoxy Glue on rear screw threads when re-attaching the housing to the receiver.

C. BOLT ASSEMBLY

1. **Loosen the receiver cap lock screw and unscrew the receiver cap. Be careful as springs inside are under compression.**
2. **Pull out the unit assembly (recoil spring, recoil spring retainer and guide sleeve, firing pin spring and firing pin spring guide head and stem). Keep all of this in order together with the receiver cap to avoid confusion I re-assembly.**
3. **With the muzzle pointing in an upward direction, retract bolt handle fully to the rear end of the receiver slot.**
4. **Push firing pin forward so as to align its tail end approximately even with the receiver cap lock screw. (Firing pin is visible and is even with the rear end of the bolt).**
5. **Pull out bolt handle and operating stud and remove bolt from the receiver.**

II. ASSEMBLY

A. BOLT ASSEMBLY

1. **Place firing pin at the rear end of the slot.**

2. **Push bolt and firing pin into the receiver and align them with respect to the receiver slot so that the bolt handle can be inserted through it past the bolt and firing pin stud clearance. Slide bolt forward with bolt handle and stud already inserted into it until it stops against the rebound lever.**
3. **While holding the trigger back with one hand, use any pointed object to trip the rebound lever by moving it to the rear away from the sear in the direction indicated by an arrow on the rebound lever. (See small sketch engraved on the trigger housing).**
4. **Push bolt handle forward sliding the bolt over the rebound lever. Release the trigger.**
5. **Insert recoil spring guide sleeve and retainer sleeve in recoil spring.**
6. **Insert firing pin spring guide into the firing pin spring.**
7. **Insert assembly #6, spring end first, into the recoil spring through the guide sleeve (shorter sleeve).**
8. **Insert the entire unit inside the receiver, shorter sleeve resting against the bolt. Place the receiver cap at the rear end of the unit assembly and compress the springs carefully to return receiver cap into its original position. Tighten the receiver cap lock screw.**
9. **Pull bolt handle back and forth several times to check the action of bolt and trigger assembly.**

B. TRIGGER ASSEMBLY

1. **With gun in upside down position, insert trigger spring follower into the trigger spring and mount it onto the spring hole.**
2. **Insert the trigger, locating the catch of the rebound lever with the rear catch.**
3. **Insert the trigger stop pin and pivot pin into their respective holes.**
4. **Squeeze trigger several times to check the action of trigger spring. (Pull bolt handle back and forth several times to check if trigger will release cocked firing pin spring).**

CAUTION

The safety in your firearm is correctly designed, fitted and tested. However, any mechanical device can fail. Never point your firearm at anything but a safe target and never rely upon the safety to justify careless handling. USE HIGH VELOCITY CALIBER 22 LONG RIFLE CARTRIDGES ONLY.

When loading, pull bolt handle fully rearward and allow it to snap forward sharply.

Breech area and magazine should be cleaned thoroughly.

SPECIFICATIONS

Model	**:**	**1600 Cal.22LR Semi-automatic Rifle**
Barrel Length	**:**	**18 inches (457.20 mm)**
Overall Length	**:**	**38.375 inches (720.73 mm)**
Weight	**:**	**6.5 lbs. (2.95 kg.)**
Magazine Capacity	**:**	**15 rounds**
Sights	**:**	**Fixed peep rear sight, Post front sight**
Stock	**:**	**Wooden stock, black finish**
Safety	**:**	**Positive thumb operated safety**

Part No.	**Part Name**
A. Barrel Receiver Assembly	
1601	**Barrel receiver cross pin**
1602	**Barrel**
1603	**Ejector**
1604	**Muzzle brake**
1605	**Muzzle brake set screw**
1606	**Front sight**
1607	**Front sight stud**
1608	**Front sight stud lock screw**
1609	**Front sight set screw**
1610	**Rear sight carrying handle**

1611 **Rear sight carrying handle screw**

1612 **Rear sight carrying handle lock screw**

1613 **Rear sight leaf**

1614 **Rear sight leaf screws**

1615 **Flash deflector**

1616 **Receiver**

1617 **Receiver cap**

1618 **Receiver cap lock screw**

B. Bolt Assembly

1619 **Bolt**

1620 **Bolt operating handle**

1621 **Bolt operating stud**

1622 **Bolt handle locating bearing**

1623 **Bolt handle locating spring**

1624 **Extractor**

1625 **Extractor plunger**

1626 **Extractor spring**

1627 **Firing pin**

1628 **Firing pin spring**

1629 **Firing pin spring guide head and stem**

1629a **Firing pin spring guide head insert**

1630 **Recoil spring**

1631 **Recoil spring guide sleeve**

1632 **Recoil spring retainer sleeve**

C. Trigger Housing Assembly

1633 **Magazine catch**

1634 **Magazine catch button**

1635 **Magazine catch pivot pin**

1635a **Magazine catch stop pin**

1635b **Magazine catch spring**

1636 **Safety latch**

1637 **Safety latch button**

1638 **Safety latch bearing**

1639 **Safety latch spring**

1640 **Safety latch screw**

1641 **Sear**

1642 **Sear pivot pin**

1643 **Sear stop pin**

1644 **Sear spring**

1645 **Sear spring pin**

1646 **Trigger**

1647 **Trigger pivot pin**

1648 **Trigger stop pin**

1649 **Trigger spring**

1650 **Trigger spring follower**

1651 **Rebound lever**

1652 **Rebound lever pivot pin**

1653 **Rebound lever safety pin**

1654 **Rebound lever spring**

1655 **Rebound lever spring bearing**

1656 **Trigger housing**

1657 **Trigger housing hold down screw (front)**

1657a **Trigger housing hold down screw washer (front)**

1658 **Trigger housing hold down screw (rear)**

1658a **Trigger housing hold down screw washer (rear)**

D. Magazine Box Assembly

1659 **Magazine box**

1660 **Magazine box inner strip**

1661 **Magazine spring**

1662 **Magazine spring follower**

1663 **Magazine spring retainer**

1664 **Magazine spring retainer pin**

1665 **Magazine cover**

1666 **Magazine release**

1667 **Magazine release pivot pin**

1668 **Magazine release spring**

1669 **Magazine box retainer pin**

E. Gun stock Assembly

1670 **Gun stock**

1671 **Butt plate**

1672 **Butt plate retainer screw**

1673 **Swivel head**

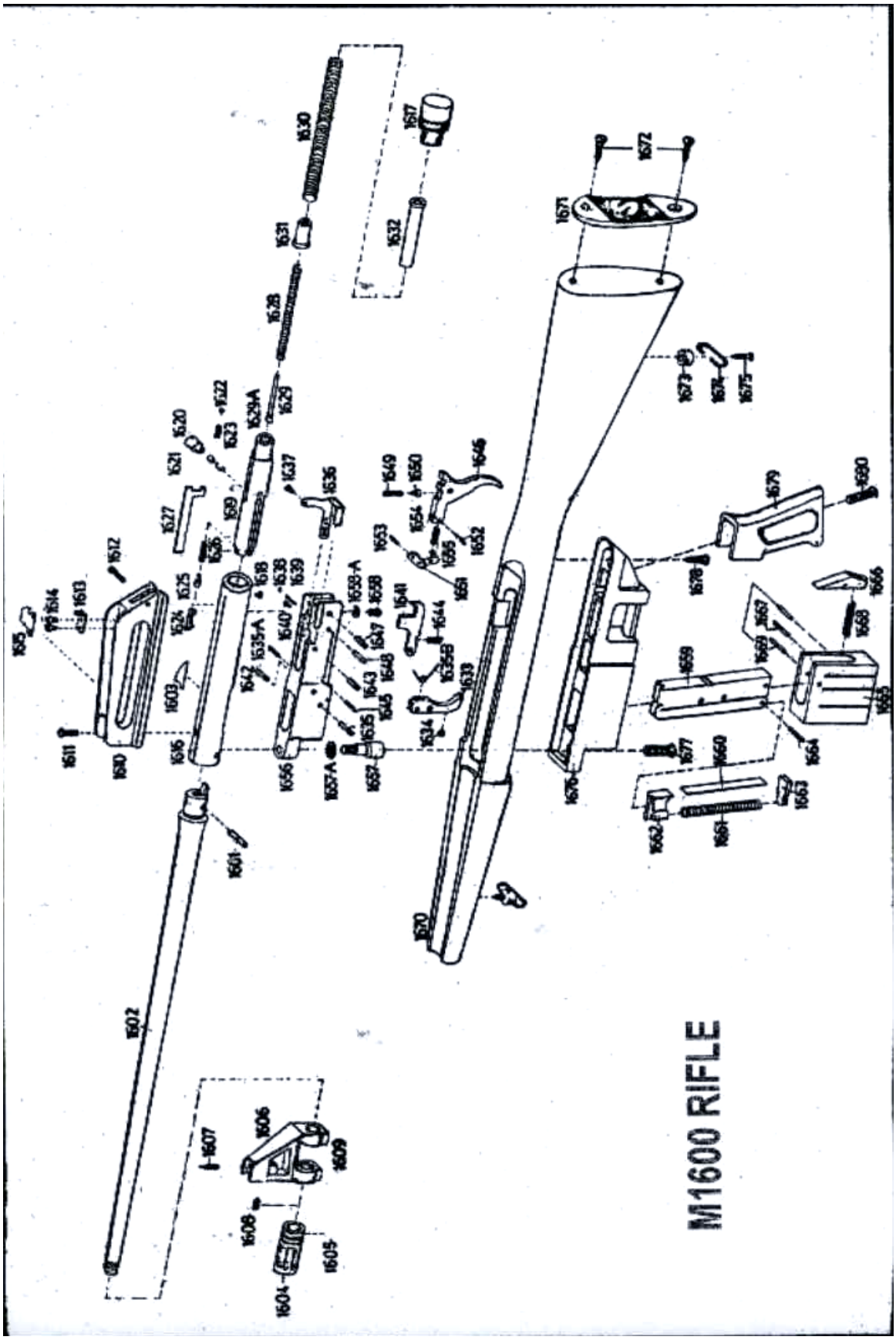
1674 **Swivel ring**

1675 **Swivel screw (front)**

1676 **Swivel screw (rear)**

1677 **Grip**

1678 **Grip screw**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